

Date: Wednesday, 1/18/2006 4:04:11 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 25553  
 Estimate Number : 10255  
 P.O. Number : N/A  
 This Issue : 1/18/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : MACHINED PARTS  
 Previous Run : 24569  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : SEE ABOVE USER & DATE  
 Comment : Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC

Drawing Name : MOUNTING LUG  
 Part Number : D22301  
 Drawing Number : D2230 REV F  
 Project Number : N/A  
 Drawing Revision : F  
 Material : N/A  
 Due Date : 1/31/2006 Qty: 200 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)

Lug Extrusion D2423 Extrusion

Batch: B23779

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 extrusion to 0.82"

Batch: B23779

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2230-1

(Check for crack while loading into the machine.)

2-Tumble and deburr rough edges after tumbling

*note P.O. # 00000446  
 1/26/06*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*N/A*

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*2-02-08*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/08

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:11 PM  
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 25553

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*a.m 06-03-01*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

*DL 06/03/07*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*M 06 03 07 (200)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 370*

*C 206/03/08 (200)*

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*D 06/03/08*

Job Completion



*U 06.03.08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

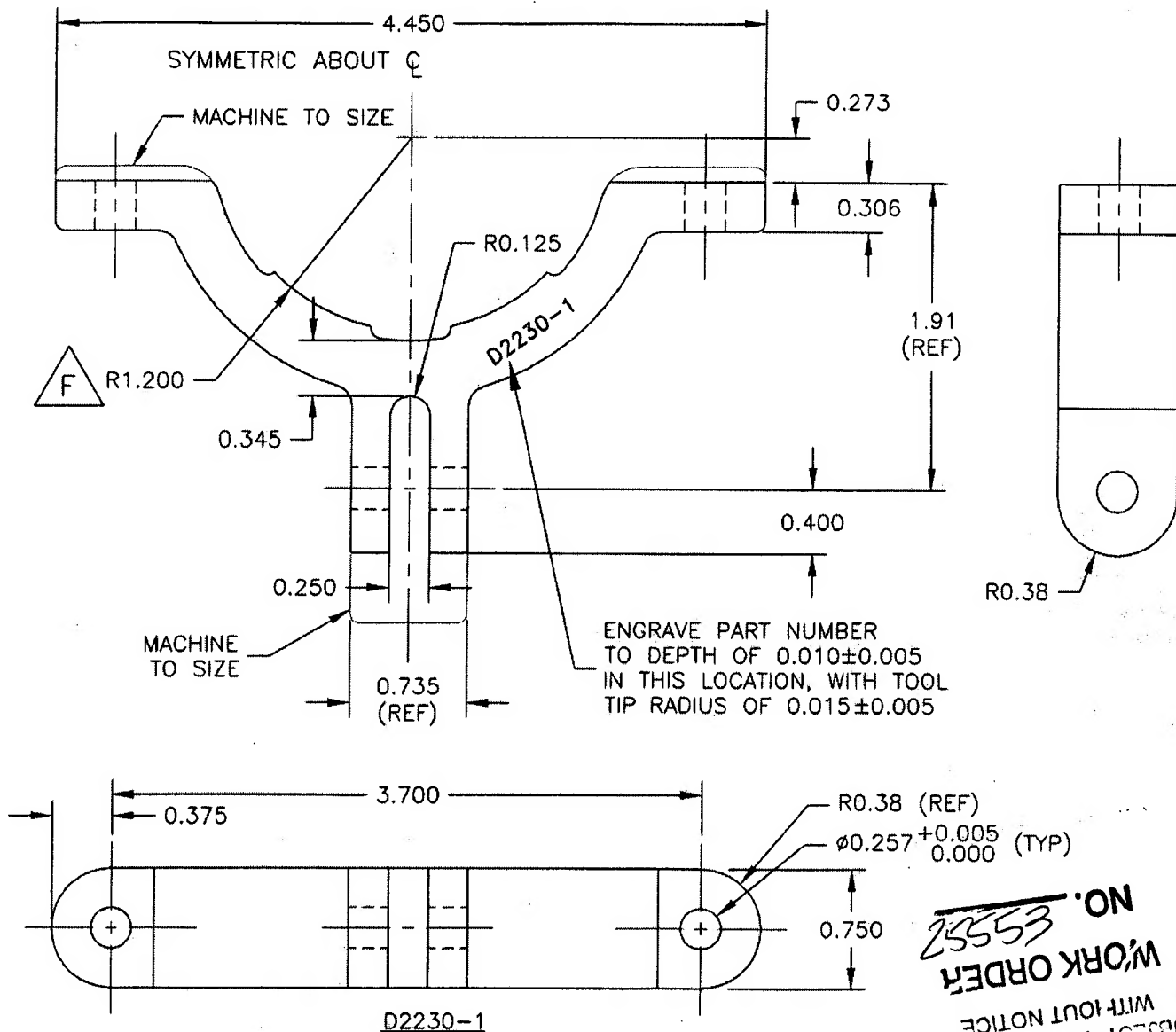
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

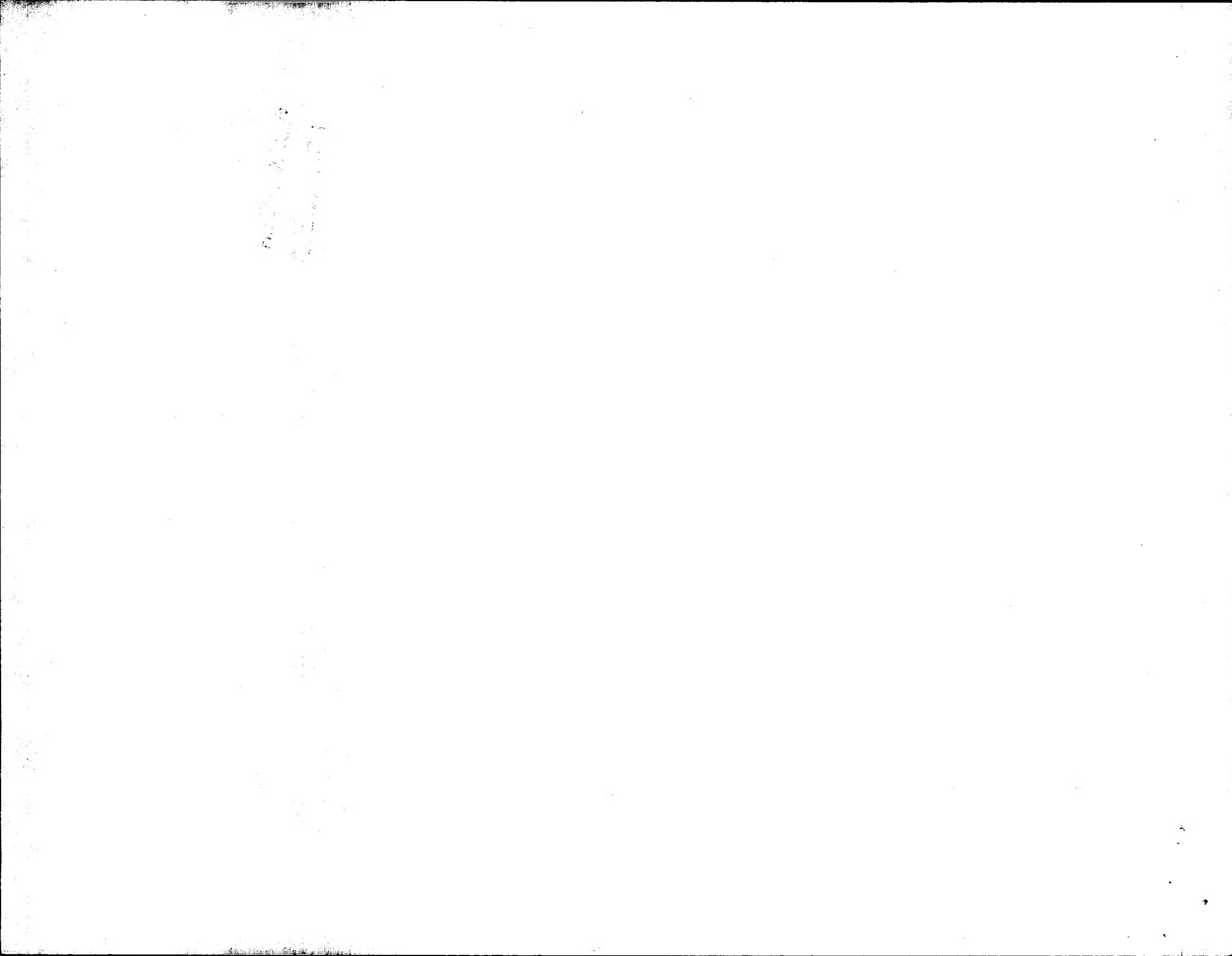
**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13	TITLE MOUNTING LUG		SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

**RELEASED**  
99.12.21 DS

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

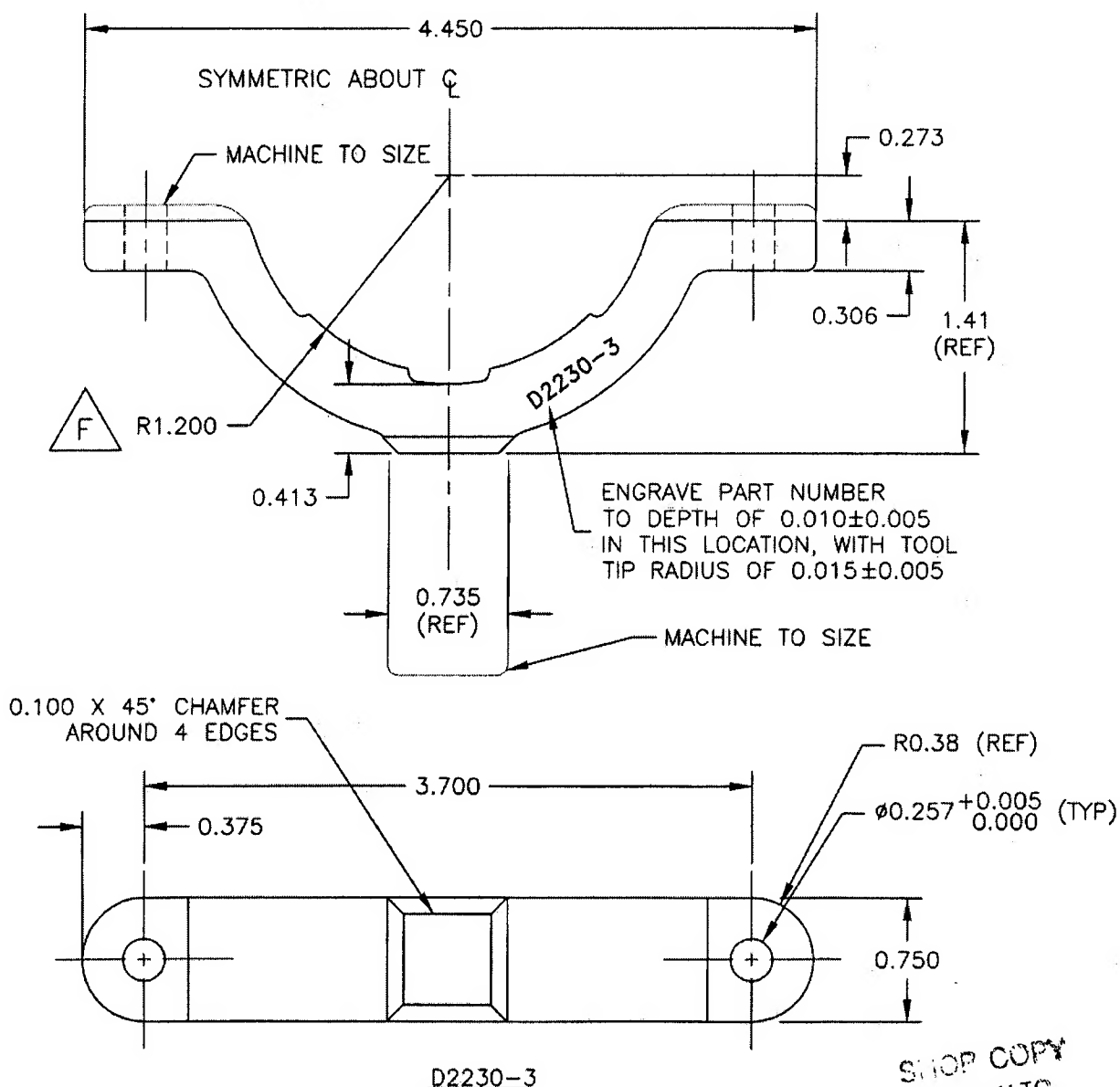
NO. 35552  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENVELOPE TO  
STAMP COPY





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
79.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
AT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25553

Delivery Slip: 15309  
 Date: 03-Feb-2006  
 Page No.: 1

Sold To: Dart Aerospace Ltd.  
 Att. Linda Lacelle  
 1270 Aberdeen Street  
 Hawkesbury, Ontario  
 K6A 1K7

Ship To: Dart Aerospace Ltd.  
 Att. Linda Lacelle  
 1270 Aberdeen Street  
 Hawkesbury, Ontario  
 K6A 1K7

Shipped by our truck					
P.O. Number	446	Quantity			Unit
		ordered	shipped	B/O	
Description					
D2731-7 MOUNTING LUG					Each
D2230-1 MOUNTING LUG		200			Each
D2230-1 MOUNTING LUG					Each
Received by _____		Thank you for your order.			

*Handwritten notes:*  
 ATT  
 LINDA LACELLE  
 06/02/06

P.O. Box 781  
 Tel. (613) 678-3957 & 678-2782

20 Terry Fox Drive  
 Fax (613) 678-3956

Vankleek Hill, Ontario, K0B 1R0  
 metec@metec.ca / www.metec.ca